

Work Order ID 67291

Tuesday, March 15, 2011 8:14:05 AM



Page 1

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step

Start Date: 3/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *HL*

Date: *11-03-13* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
N/A	Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP205-633-011 CHG001

8/10/12

11/4/26

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/4/26

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/10/12

74

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step

Start Date: 3/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging	Packaging	0.00							
	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location: <u>70</u>								<u>Rec'd</u>
140 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

Rec'd 4/28MF 11-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Tuesday, March 15, 2011 8:14:12 AM

Page 1

Work Order ID: 67291

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step



Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:F02.07.11 Reformat; Removed D3010 RFI

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A Bolt		Purchased	No			110	Each	243.0000	1	4			
-----------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST357	243	
113359	3	
114752	1	
116419	9	
116786	130	
116914	100	

AN4-5A Bolt		Purchased	No			110	Each	196.0000	2	8			
----------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST356	196	
115936	46	
116191	100	
116549	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 67291

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A Purchased No

110 Each

1,418.000 2

8



Bolt

Location

Loc Qty

Loc Code

ST356

1418

112933

96

113149

17

115108

5

115936

200

116191

300

116400

400

116924

400

AN4-7A Purchased No

110 Each

76.0000 2

8



Bolt

Location

Loc Qty

Loc Code

ST356

76

113226

30

115373

46

AN5-14A Purchased No

110 Each

121.0000 1

4



Bolt

Location

Loc Qty

Loc Code

ST337

26

115429

26

ST338

95

115374

95

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 67291

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 4.00

Required Qty: 4.00

AN5-6A Purchased No

110 Each

18.0000

1



Bolt

Location

Loc Qty

Loc Code

ST337

18

112243

18

AN960JD416 NAS1149D0463J Purchased No

110 Each

30.0000

15



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

AN960JD516 NAS1149D0563J Purchased No

110 Each

34.0000

4



Washer

Location

Loc Qty

Loc Code

ST298

34

103694

18

107534

12

109287

4

.D2021-101 Manufactured No

110 Each

24.0000

1



Eyebolt

Location

Loc Qty

Loc Code

ST004

24

59808

4

62464

20

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 67291

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 4.00

Required Qty: 4.00

S_{SM}
D2022-101

Manufactured No

110 Each

61.0000

2 8



Spacer

Location

Loc Qty

Loc Code

ST504

61

63318

1

66939

60

S_{SM}
D2022-103

Manufactured No

110 Each

58.0000

2 8



Spacer

Location

Loc Qty

Loc Code

ST005

58

47964

58

S_{SM}
D2562-001

Manufactured No

110 Each

12.0000

1 4



Strut

Location

Loc Qty

Loc Code

ST264

12

61626

4

64803

8

S_{SM}
D2563

Manufactured No

110 Each

0.0000

1 4



Step Weldment Assembly

S_{SM}
D2565-101

Manufactured No

110 Each

23.0000

1 4



Strut

Location

Loc Qty

Loc Code

ST270

23

60503

7

64798

8

66833

8

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 67291

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 4.00

Required Qty: 4.00

D2565-103

Manufactured No

110

Each

21.0000

1

14



Strut

Location

Loc Qty

Loc Code

ST270

21

60504

5

65472

8

66839

8

D2565-105

Manufactured No

110

Each

14.0000

1

4



Strut

Location

Loc Qty

Loc Code

ST270

14

60505

5

64796

9

D2565-107

Manufactured No

110

Each

23.0000

1

4



Strut

Location

Loc Qty

Loc Code

ST270

23

60506

7

64800

8

66834

8

D2565-109

Manufactured No

110

Each

15.0000

1

4



Strut

Location

Loc Qty

Loc Code

ST270

15

60507

7

64797

8

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 67291

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 4.00

Required Qty: 4.00

D2565-111

Manufactured No

110

Each

19.0000

1

4



Strut

Location

Loc Qty

Loc Code

ST270

19

60508

4

64799

8

66835

7

MS21042L4

Purchased

No

110

Each

4,333.000

8

32



Nut

Location

Loc Qty

Loc Code

ST300

4333

1123143

2

115589

10

115621

20

116188

2301

116823

2000

MS21042L5

Purchased

No

110

Each

962.0000

2

8



Nut

Location

Loc Qty

Loc Code

ST300

962

114813

26

115594

240

116105

496

116548

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: B

Date: 07.08.21

